

Work Order ID 58345

Monday, May 03, 2010 3:03:04 PM



Page 1

Item ID: D3908-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud Receiver, Lower

Start Date: 5/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 5/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 10-5-3 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3908 | B |

| | | |
|-----|-------------------------|------|
| 100 | Cut blanks as per folio | 0.00 |
|-----|-------------------------|------|



Bandsaw

Memo

Jeaspa Bandsaw

CUT BLANK 4.00" LONG

0.00

mk 10/05/08/JL 10/05/11

12 0

110



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA866 AND DWG

FOLIO REV: 44

DWG REV: B

DEBURR

0.00

mk 10/05/10/JL 10/05/11

1

PTO

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3908-3 PAR #: _____ Fault Category: Machining ~~Prod Eng~~ NCR: Yes No DQA: _____ Date: 09/10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/05/12

| NCR: <u>S8345</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------------|--|---------------------------------------|---|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>10/05/10</u> | <u>110</u> | <u>1 part, the Ø.453 hole was too deep of .015" over tol. and the chamfer too deep of .040".</u> <u>R.C. program error.</u> | <u>[Signature]</u> <u>05/10/12</u> | <u>Tools & origin were verified & were good.</u> <u>Program error: Adjust/correct program.</u> <u>Scrap & destroy Qty 1</u> | <u>[Signature]</u> <u>10/05/10</u> | <u>[Signature]</u> <u>10-05-10</u> | <u>[Signature]</u> <u>05/10/12</u> | <u>[Signature]</u> <u>10/05/10</u> |
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NOTE: Date & initial all entries

Work Order ID 58345

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

amt 10/05/10

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Ins/10-05-11

12

160

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

B 58502
B 58503

SB 10/05/12

(12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58345

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Item ID: D3908-3

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12

ME
10-5-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 3:03:04 PM

Page 1

Work Order ID: 58345



Parent Item: D3908-3



Parent Item Name: Stud Receiver, Lower

Start Date: 5/4/2010

Required Date: 5/12/2010

Comments: IPP REV:A NEW ISSUE 09-11-24 JLM VERIFIED BY:DD IPP Rev:B
as per dwg revB DD 10.04.20 verified by:EC

Start Qty: 12.00

Required Qty: 12.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| M303B1.000X2.000 | | Purchased | No | | | 100 | f | 5.6947 | 0.333333 | | | |
| | | | | | | | | | | | | |
| 303 BAR 1" X 2" | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

MAT53

5.6947

→ 113390

5.6947

4.2053 on 10/05/08

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|---|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 58345 |
| Description: Stud Receiver Lower | | Part Number: D3908-3 |
| Inspection Dwg: D3908 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| Ø0.25 | +0.005/-0.001 | Ø.251 | ✓ | | | |
| 0.625 | +/-0.010 | .624 | ✓ | | | |
| 0.368 | +/-0.010 | .366 | ✓ | | | |
| Ø0.453 | +0.010/-0.000 | Ø.457 | ✓ | | | |
| 1.95 | +/-0.030 | 1.943 | ✓ | | | |
| Ø0.38 | +/-0.030 | Ø.378 | ✓ | | | |
| 0.63 | +/-0.030 | .623 | ✓ | | | |
| 2.43 | +/-0.030 | 2.423 | ✓ | | | |
| 0.63 | +/-0.030 | .623 | ✓ | | | |
| 0.75 | +/-0.030 | .750 | ✓ | | | |
| 0.38 | +/-0.030 | .375 | ✓ | | | |
| R0.06 | +/-0.030 | R.060 | ✓ | | | |
| R0.25 | +/-0.030 | R.250 | ✓ | | | |
| 3.80 | +/-0.030 | 3.804 | ✓ | | | |
| 0.735 | +0.000/-0.010 | .730 | ✓ | | | |
| Ø0.129 | +0.005/-0.001 | Ø.129 | ✓ | | | |
| 1.25 | +/-0.030 | 1.250 | ✓ | | | |
| 15° | +/-0.5° | 15° | ✓ | | | |
| 1.587 | +/-0.010 | 1.583 | ✓ | | | |
| 1.588 | +/-0.010 | 1.583 | ✓ | | | |
| 0.31 | +/-0.030 | .314 | ✓ | | | |
| 0.750 | +/-0.010 | .755 | ✓ | | | |
| 0.95 | +/-0.030 | .948 | ✓ | | | |
| 0.99 | +/-0.030 | .990 | ✓ | | | |
| 90° | +/-0.5° | 90° | ✓ | | | |
| 0.06 x 45° | +/-0.030 x 0.5° | .063 x 45° | ✓ | | | |
| 0.80 | +/-0.030 | .800 | ✓ | | | |
| | | | | | | |
| | | | | | | |

| | | |
|--------------------------------|---------------------------------------|------------------------------|
| Measured by: <i>amk</i> | Audited by: <i>[Signature]</i> | Preliminary Approval: |
| Date: 10/05/10 | Date: 10.05.11. | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A | 10.04.01 | New Issue | KJ | |
| B | 10.04.20 | Dwg Rev updated | KJ | |

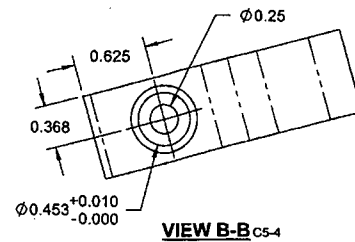
| W/O: | | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

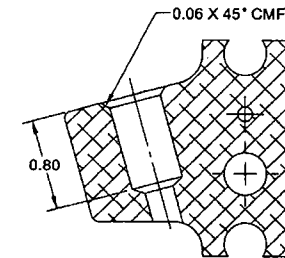
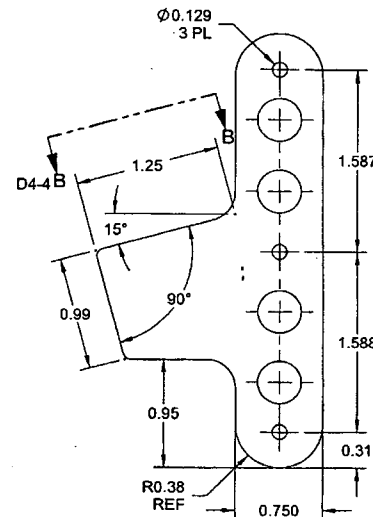
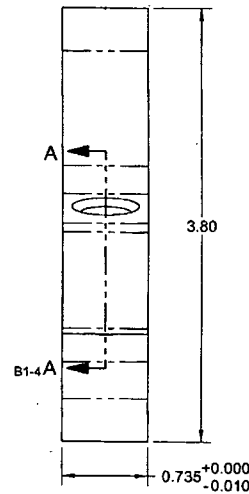
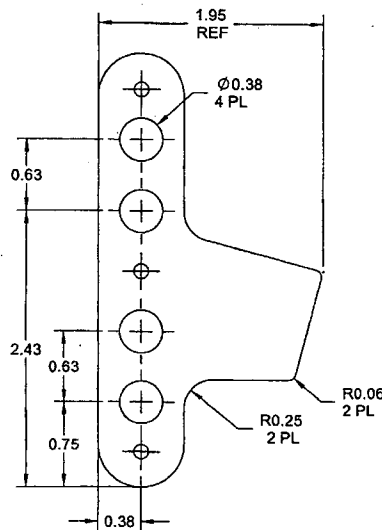
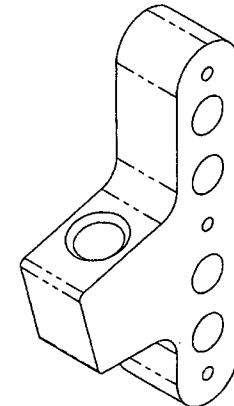
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries



#58345



SECTION A-A B6-4

RELEASED
2010-04-14
MP

D3908-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | JPH | DRAWING NO. D3908 | REV. B |
| MFG. APPR. | JPH | TITLE X-TUBE LUG ASSY (AFT) | SHEET 4 OF 5 |
| APPROVED | JPH | SCALE | NTS |
| DE APPR. | JPH | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
| DATE | 10.04.06 | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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